








# Work Order ID 66908

Wednesday, March 02, 2011 2:19:16 PM


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Item ID: D4191-3	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Housing Cover					
Start Date: 3/2/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 3/25/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/03/02</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4191	<u>PA6</u>								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank to 3.40"								
	Batch: <u>112154</u>								

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio EA986								
	DWG REV: <u>PA6</u>								
	FOLIO REV: <u>AA</u>								
	FACE PART MANUALLY TO SIZE								
	2- deburr rough edges								

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY



PRELIMINARY ISSUE

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66908**

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Item ID: D4191-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Housing Cover

Start Date: 3/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		B.A 11/03/23		2	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		OK 11/04/27		2	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				2	BR 11-4-27		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66908

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Item ID:	D4191-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Housing Cover					
Start Date:	3/2/2011	Start Qty: 2.00		Cust Item ID:		
Required Date:	3/25/2011	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00				2	0	21	4/04/23
QC Quality Control	Memo	0.00							
180 	Identify as per dwg & Stock Location: <u>HARRY</u>	0.00							
Packaging Packaging	Memo	0.00							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

RD2334

11-07-18

POSITIVE RECALL  
EFFECTIVE 11-07-18 AUTH u  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Wednesday, March 02, 2011 2:19:12 PM

Work Order ID: 66908



Parent Item: D4191-3



Parent Item Name: Housing Cover

Start Date: 3/2/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No			100	f	41.7636	0.283	0.595789			



6061-T6 Bar .500 x 5.00



SL 11/03/23

Location

Loc Qty

Loc Code

MAT03

41.7636

112041

18.9

112154

22.8636

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

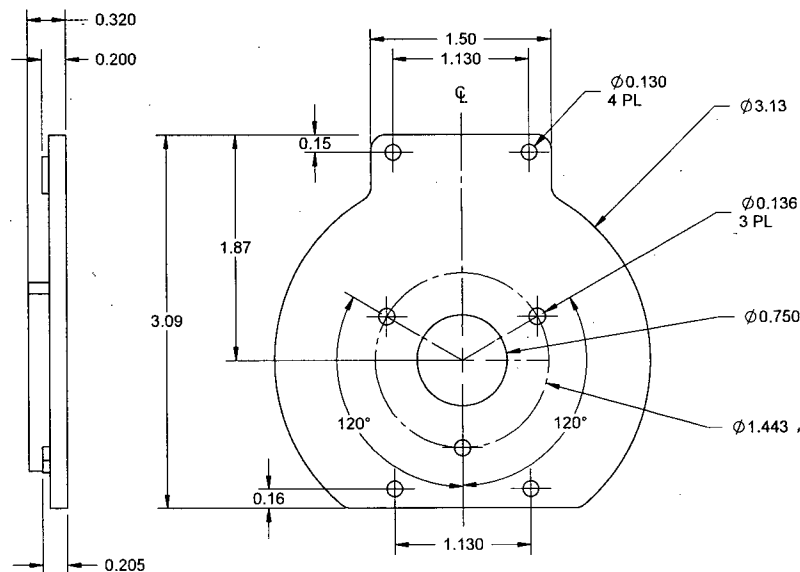
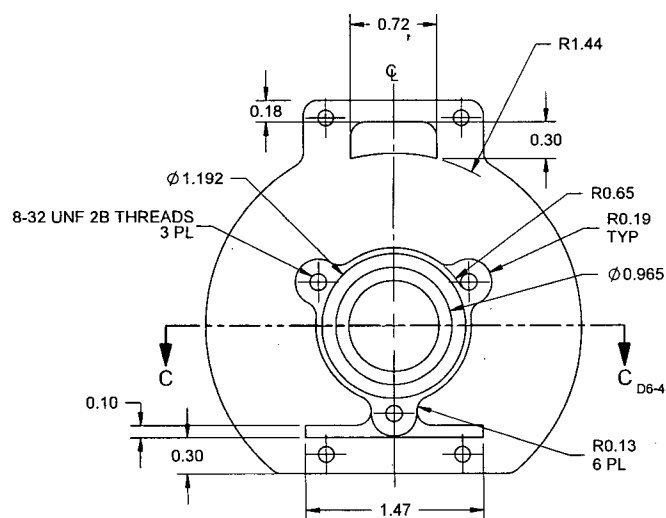
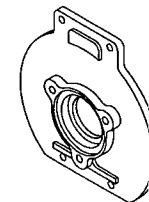
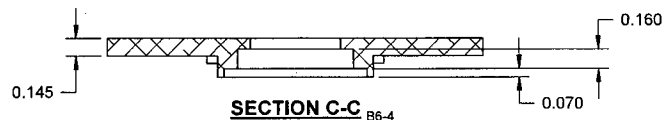
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8  
OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS-QQ-A-200/8  
OR AMS 4160  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

## D4191-3 HOUSING COVER

PRELIMINARY ISSUE

10.11.17

CD 11/03/02  
W/O: 66908

DESIGN	<del>15</del>	DART AEROSPACE LTD	
DRAWN	<del>15</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>15</del>	DRAWING NO.	REV. PA6
MFG. APPR.	<del>15</del>	D4191	SHEET 4 OF 1
APPROVED	<del>15</del>	TITLE	SCALE
DE APPR.	<del>15</del>	CONTROL BOX	NTS
DATE	10.11.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 66908
Description: HOUSING COVER		Part Number: D4191-3
Inspection Dwg: D4191 Rev: PA6		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.145	+/- .010	0.145	✓		Mic	GA-03
0.160	+/- .010	0.160	✓		"	"
0.070	+/- .010	0.071	✓		"	"
0.30	+/- .030	0.303	✓		Vern	GA-01
0.72	+/- .030	0.720	✓		"	"
0.18	+/- .030	0.179	✓		"	"
φ 1.192	+0.012 / - .001	φ 1.193	✓		"	"
8-32 UNF 2B	N/A	8-32 UNF 2B	✓		8-32 UNF bolt	ref.
0.10	+/- .030	0.100	✓		Vern	GA-01
0.30	+/- .030	0.298	✓		"	"
1.47	+/- .030	1.470	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
φ 0.965	+0.010 / - .001	φ 0.965	✓		Vern	GA-01
R0.19	+/- .030	R0.188	✓		R-6	ref.
R0.65	+/- .030	R0.645	✓		Vern	GA-01
0.326	+/- .010	0.322	✓		Vern	GA-01
0.200	+/- .010	0.200	✓		"	"
0.205	+/- .010	0.215	✓		"	"
φ 0.130	+0.005 / - .001	φ 0.130	✓		"	"
1.50	+/- .030	1.500	✓		"	"
1.130	+/- .010	1.130	✓		"	"
0.15	+/- .030	0.145	✓		"	"
1.87	+/- .030	1.873	✓		"	"

Measured by: B.A	Audited by: <i>amf</i>	Prototype Approval:
Date: 11/03/23	Date: 11/04/27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

